

Work Order ID 80509

80509

Page 1

February-21-12 5:19:20 PM

Item ID: D350-588-011

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop

NS2

Start Date: 21/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/21

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

100

DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

M.C.J. 12/04/16

110

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

12/3/30

120

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

12/4/16

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80509

80509

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February-21-12 5:19:20 PM

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>125</u>								
	PPP Rev: <u>Q</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS 12/04/16

12-04-16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:M04.08.31 Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

100.0000

2.

20

**

AN526C1032R7

Screw

Location

Loc Qty

Loc Code

ST348

100

116304

8

119449

92

120

Each

147.0000

8

80

**

AN526C832R8

Purchased

No

AN526C832R8

Screw

Location

Loc Qty

Loc Code

ST346

100

120717

100

ST347

47

118926

5

119798

42

120

Each

220.0000

8

80

**

AN526C832R9

Purchased

No

AN526C832R9

Screw

Location

Loc Qty

Loc Code

ST346

200

120181

200

ST347

20

118983

20

120

Each

0.0000

40

AN960JD10

NAS1149D0363J Purchased

No

AN960JD10

Washer

12/4/13

M120611

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD8 NAS1149DN832 Purchased No

120 Each 0.0000 24 -240

SAD *AN960.ID8*

Washer

D2143 Manufactured No

120 Each 26.0000 1 10

SAD *D2143*

Hinge Bracket

Location

Loc Qty

Loc Code

ST -12

76100 26

ST198 38

D2144 Manufactured No

120 Each 0.0000 1 10

SAD *D2144*

Hinge Bracket

D2150 Manufactured No

120 Each 22.0000 2

SAD *D2150*

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST005 22

76953 22

D2151 Manufactured No

120 Each 26.0000 2 20

SAD *D2151*

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST005 26

76093 26

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 80509

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Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

S
AD
D2153
D2153
Door Prop

Manufactured No 120 Each 70.0000 1

**

10
5/1

Location Loc Qty Loc Code

ST272 70
78369 70

120 Each 19.0000 1

**

10
10

S
AD
D2154
D2154
Stud Bracket

Manufactured No 120 Each 19.0000 1

**

Location Loc Qty Loc Code

ST005 19
77024 19

120 Each 32.0000 2

**

20
10/10

B82062

S
AD
D2237
D2237
Striker Plate

Manufactured No 120 Each 32.0000 2

**

Location Loc Qty Loc Code

ST006 32
66139 1
77046 29
77872 2

120 f 290.9887 7.25

**

7631579
12/1/13

S
AD
D2461
D2461
Neoprene "D" Seal

Manufactured No 120 f 290.9887 7.25

**

Location Loc Qty Loc Code

ST402 290.9887
39782 6.5
55054 4
63880 7.6237
73644 272.865

cut 1 X 87.00"

measured
87.00"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2463 Manufactured No

120 f

529.3369 7.25 6.31579

S *D2463*

Seal

**

Location

Loc Qty

Loc Code

ST404

529.3369

72232

36.88

79478

492.4569

cut 1 X 87.00"

D2583

Manufactured No

120 Each

27.0000 2 20

S *D2583*

Latch Bracket

**

Location

Loc Qty

Loc Code

ST011

27

78402

27

D2585

Manufactured No

120 Each

78.0000 2

S *D2585*

Mounting Channel

**

Location

Loc Qty

Loc Code

ST011

78

73297

2

77696

17

78805

59

D2586

Manufactured No

120 Each

69.0000 2 20

S *D2586*

Door Latch

**

Location

Loc Qty

Loc Code

ST203A

69

77697

69

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2587

Manufactured No

120

Each

53.0000

1

10

D2587

Door Slug, 350 Hinge

**

Location

Loc Qty

Loc Code

ST011

53

74522

1

78893

52

D2589

Manufactured No

120

Each

22.0000

1

10

D2589

Keys, Key Chain, 350 Hinge

**

Location

Loc Qty

Loc Code

ST011

22

58194

22

D2690-17

Manufactured No

120

Each

16.0000

1

10

D2690-17

Cable

**

Location

Loc Qty

Loc Code

ST016

16

66510

1

76139

15

D2857-1

Manufactured No

120

Each

23.0000

1

10

D2857-1

Hinge Bracket

**

Location

Loc Qty

Loc Code

ST019

23

69932

1

75253

22

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

80509

D350-588-011

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2857-2 Manufactured No

120 Each

18.0000

1

10

**

D2857-2

Hinge Bracket

Location

Loc Qty

Loc Code

ST019

18

75252

18

120 Each

29.0000

1

10

**

D2858-1

Manufactured No

D2858-1

Hinge Bracket

Location

Loc Qty

Loc Code

ST019

29

75250

8

77019

21

120 Each

24.0000

1

10

**

D2858-2

Manufactured No

D2858-2

Hinge Bracket

Location

Loc Qty

Loc Code

ST019

24

75251

4

77020

20

120 sf

3,246.651

1

10

**

FG-778150-550-ROL

Purchased

No

*FG-778150-550-ROI *

7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

3246.651

104845

3

108932

18

111166

392

113905

563

117602

680.651

119099

1590

1- cut 1 square ft of glass cloth

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS20426AD3-4 Purchased No

120 Each 4,006.000 12 120

MS20426AD3-4

RIVET

**

Location

Loc Qty

Loc Code

ST316

4006

104374

1024

110398

2982

MS20470AD4-5 Purchased No

120 Each 3,015.000 18 180

MS20470AD4-5

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

3015

118405

1362

120142

1653

MS21042L08 Purchased No

120 Each 323.0000 18 180

MS21042L08

Nut

**

Location

Loc Qty

Loc Code

ST300

323

120142

123

120648

200

MS21042L3 Purchased No

120 Each 4,257.000 4 40

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

4257

117441

16

117885

32

118451

5

118927

3

119017

3894

119075

307

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS27039-08-11

Purchased

No

120

Each

41.0000

2

20

MS27039-08-11

Screw

**

Location

Loc Qty

Loc Code

ST290

41

117441

41

120

Each

89.0000

2

20

MS27039-1-15

Purchased

No

MS27039-1-15

Screw

**

Location

Loc Qty

Loc Code

ST291

89

118093

22

118574

2

119736

65

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00